

Work Order ID 111455

111455

Page 1

January-15-14 1:10:47 PM

Item ID: D350-766-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Interior Trim - Ceiling
 Start Date: 1/15/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/30/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: AP/MLJ Date: 14-01-16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D350-766	Rev C								

100 DOCUMENT CONTROL 0.00
100
 DC Memo MLJ 0.00 DAS
 Document Control Photocopy bluefile & type labels per PPP D350-766-013 CHG002
 9-89 MLJ 14-02-03

110 Pick Kit 0.00
110
 Packaging Memo 0.00 DAS
 Packaging 1x 28
 9-89 14-02-03

120 QC4- 100% Inspect kits for completeness 0.00
120
 QC Memo 0.00 DAS
 Quality Control 6
 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-766-013 Location: <u>EG 160</u> PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

1 \$ 14-02-03 SL
MLJ 14-02-04
AD 14-02-03

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Equip/Tooling									
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January-15-14 1:10:46 PM

Required Qty: 1.00

Comments: IPP REV A NEW ISSUE 08/04/08 DL verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3656-1 Aft Panel	DAS 6 9-89	DAS 6 9-89	Manufactured	No		110	Each	0.0000	1	1			DAS 28 9-89
D3656-3 Panel			Manufactured	No		110	Each	0.0000	1	1			DAS 28 9-89
ANS26-1032R9 Screw	DAS 6 9-89		Purchased	No		110	Each	172.0000	15	15			DAS 28 9-89
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST328	22							
					123831	22							
					ST345	100							
					M127363	100							
					ST346	50							
					M126105	50							
CCR264SS3-3 Cherry Rivet	DAS 6 9-89		Purchased	No		110	Each	416.0000	30	30			DAS 28 9-89
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST327	416							
					m126282	216							
					m126333	200							
MS21059L3 Nut Plate	DAS 6 9-89		Purchased	No		110	Each	232.0000	15	15			DAS 28 9-89
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST315	100							
					M127916	100							
					ST316	132							
					M127743	132							

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REFERENCE ONLY

14-23

DART AEROSPACE LTD.

IIN-D350-766

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DAS

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9-89

4.0 WEIGHT AND BALANCE

The following is the weight increase associated with the Interior Trim Kits. Be sure to subtract the weight of any parts removed.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-766-011 Interior Trim Kit (Aft Bulkhead Trim Kit)	13.2 lb 6.0 kg	0 in 0 m	0 in-lb 0 m-kg	113 in 2.87 m	1492 in-lb 17.2 m-kg
D350-766-013 Interior Trim Kit (Ceiling Trim Kit)	11.0 lb 5.0 kg	0 in 0 m	0 in-lb 0 m-kg	91 in 2.31 m	1001 in-lb 11.6 m-kg
D350-766-015 Interior Trim Kit (Canopy Post Trim Kit)	5.2 lb 2.4 kg	0 in 0 m	0 in-lb 0 m-kg	42 in 1.07 m	218 in-lb 2.6 m-kg
D350-766-021 Interior Protector Kit (Aft Baggage Protector Kit)	14.3 lb 6.5 kg	2.77 in 0.07 m	39.6 in-kg 0.46 m-kg	168 in 4.27 m	2402 in-lb 27.8 m-kg

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -021	Part Number	Description
X	X			D350-766-011	INTERIOR TRIM KIT (AFT BULKHEAD TRIM KIT)
				D350-766-013	INTERIOR TRIM KIT (CEILING TRIM KIT)
		X		D350-766-015	INTERIOR TRIM KIT (CANOPY POST TRIM KIT)
			X	D350-766-021	INTERIOR PROTECTOR KIT (AFT BAGGAGE PROTECTOR KIT)
1				D3655-1	PANEL
1				D3655-3	PANEL
	1			D3656-1	PANEL
	1			D3656-3	PANEL
			1	D3889-041	PANEL, FLOOR
			1	D3890-041	PANEL, WALL
			1	D3891-041	PANEL, FWD LH
			1	D3891-042	PANEL, FWD RH
			1	D3944-1	PLACARD
			4	D3945-041	BRACKET
		1		D3946-1	PANEL, CENTER POST
		1		D3947-1	PANEL, UPPER LH POST
		1		D3947-2	PANEL, UPPER RH POST
		1		D3947-3	PANEL, LOWER LH POST
		1		D3947-4	PANEL, LOWER RH POST
			3	D3948-041	PLATE, ANCHOR
			4	D3948-043	PLATE, ANCHOR
			14	AN525-10R7	SCREW
			4	AN525-10R9	SCREW
2				AN526-1032R12	SCREW
2				AN526-1032R20	SCREW
	15			AN526-1032R9	SCREW
			8	CCR264SS3-2	RIVET
	30			CCR264SS3-3	RIVET
8				CCR274SS3-4	RIVET
			8	CR3213-4-02	RIVET (OR M7885/2-4-02)
			12	CR3523-4-02	RIVET (OR M7885/4-4-02)
			16	CR3523-4-03	RIVET (OR M7885/4-4-03)
4	15		4	MS21059L3	NUTPLATE (OR MS21059-3)

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Revision: C

Date: 09.06.08